



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5569-3

Job Sheet 196780



Part No: D5569-3

Job Qty: 10 pcs

Part Name: Replacement Blade - Basic Aluminum



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/20/19

Job Tracking No:

Due Date: 7/12/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D5569-3 REV:C IPP REV A 19.06.19 NEW ISSUE JFS VERIFIED BY DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Mori Seiki TL-40 - 1	10 pcs		7/12/19	1.00	40.00	Mori Seiki TL-40 - 1		DAS 66 9-89 2019/06/29
110	QC 2	10 pcs		7/12/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		DAS 66 9-89 2019/06/29
							QC 2 - 66		
							QC 2 - 64		

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DART
AEROSPACE

Container No: S194976



Part: D5569-3

Job No: 196780

Serial No/Batch: S194976

Revision: C
Inspector:
Exp Date:
Instructions:

Date: 07/02/19

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

0-88
88
DAS

0-88
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DAS

					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
120	HAAS 5 Axis - B4B	10 pcs	7/12/19	0.75 20.00	HAAS - 5 - B4B	mm 2019/07/11
130	QC 2	10 pcs	7/12/19	0.00 0.00	QC 2 - 1	
					QC 2 - 12	
					QC 2 - 14	
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	
					QC 2 - 44	
					QC 2 - 45	
					QC 2 - 48	
					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	mm 2019/07/11
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
140	QC 8	10 pcs	7/12/19	0.00 0.00	QC 8 - 12	mm 19/07/12
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	

DAS
64
9-89DAS
64
9-89

140 HAND FINISH H1-3						QC 8 - 67 1-3	JUL 15 2019
						QC 8 - 1 (A)	
						QC 8 - 47	
						QC 8 - 40	
						QC 8 - 52	
						QC 8 - 23	
						QC 8 - 57	
180 Powdercoat - 1 White GI(A)-	10	7/12/19	0.00	0.35	Powdercoat - 1 - B4B		
B4B M175459	pcs				Powdercoat - 2 - B4B		
					Powdercoat - 3 - B4B	BR 19-7-15	
					Powdercoat - 4 - B4B		
START: 1:15 O.V.T. 320° FINISH: 1:45.					QC 3 - 10		
190 QC 3	10	7/12/19	0.00	0.00	QC 3 - 13		
	pcs				QC 3 - 15		
					QC 3 - 17		
					QC 3 - 18		
					QC 3 - 2		
					QC 3 - 28		
					QC 3 - 3		
					QC 3 - 30		
					QC 3 - 34		
					QC 3 - 36		
					QC 3 - 41		
					QC 3 - 51		
					QC 3 - 58		
					QC 3 - 59		
					QC 3 - 68		
					QC 3 - 9		
					QC 3 - 40	DAS	
					QC 3 - 19	81	JUL 15 2019
					QC 3 - 43	9-89	
					QC 3 - 24		
200 Packaging 3-1 - Stock - B4B	10	7/12/19	0.00	0.00	Packaging 3 - 1 -		
	pcs				B4B		
					Packaging 3 - 2 -		
					B4B		
					Packaging 3 - 3 -		
					B4B		
					Packaging 3 - 4 -		
					B4B		
					Packaging 3 - 5 -		
					B4B		
					Packaging 3 - 6 -		
					B4B		
					Packaging 3 - 7 -		
					B4B		
					Packaging 3 - 8 -		
					B4B		
					Packaging 3 - 9 -		
					B4B		
					Packaging 3 - 10 -		
					B4B		
					Packaging 3 - 11 -		
					B4B		
					Packaging 3 - 12 -		
					B4B		
					Packaging 3 - 13 -		
					B4B		
					Packaging 3 - 14 -		
					B4B		
					Packaging 3 - 15 -		
					B4B		

					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	Pc ST229 B
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
210 QC 21 - SA	10 pcs	7/12/19	0.00	0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	JUL 16 2019
					QC 21 - SA - 53	DAS 70 9-89

Part Op 100 - Mori Seiki TL-40 (Mori Seiki CNC Lathe Large) 1-Cut blanks at 22.800" 2-Turn as per dwg. and folio
 Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)
 120 - HAAS 5 Axis (HAAS CNC vertical machine #5) 1-Machine as per Folio FC763 and Dwg. D5569-3
 130 - (QC2- Inspect parts off machine FAI/FAIB)
 140 - (QC8- Inspect parts - second check)
 180 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____
 190 - (QC3- Inspect Part Finish)
 200 - (Identify as per dwg & Stock Location: _____) LOCATION : FP001
 210 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6008-132	Crosstube Extrusion	1.7300 pcs (.173 ea)	100-Mori Seiki TL-40 - 1	F91808

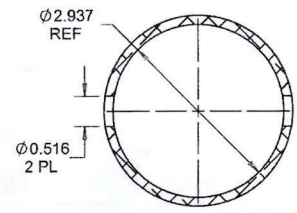
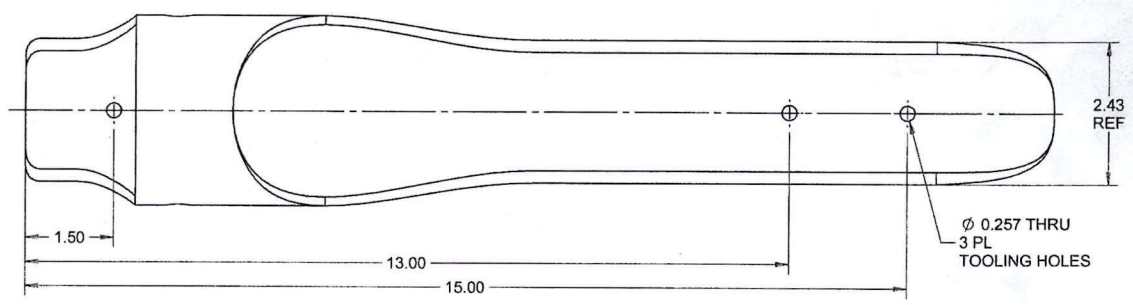
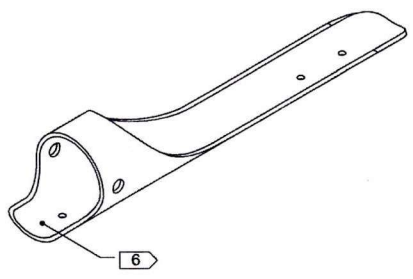
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Mori Seiki TL-40 - 1	D6008-132	2	61	0

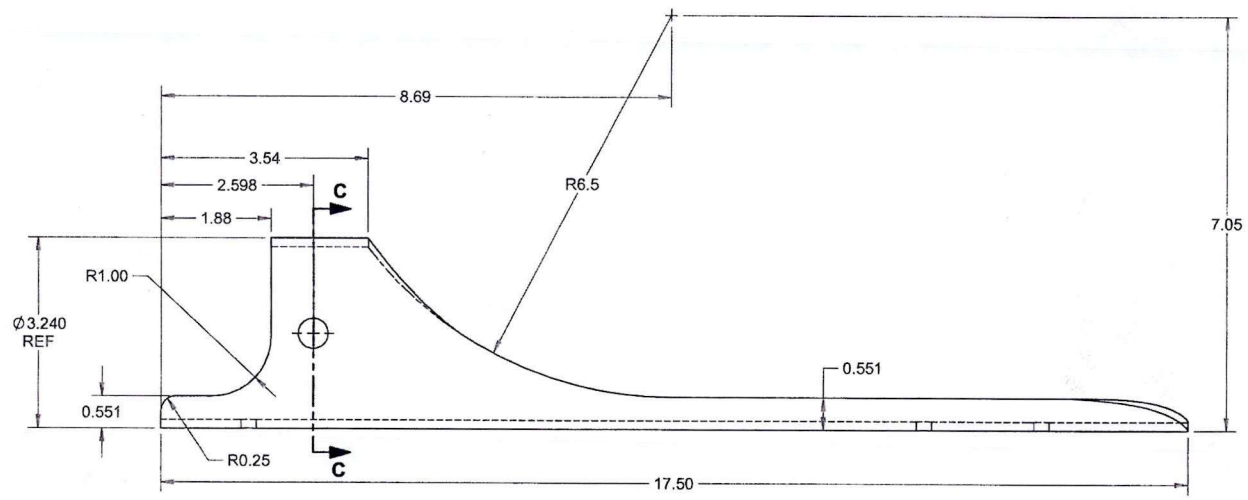
Part Specifications	
Specifications could not be found.	

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8 7 6 5 4 3 2 1



SECTION C-C



D5569-3 SKIDTUBE BLADE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 196780
MWS
19-06-20

RELEASED
2019 JUN 19 NO

- NOTES:**
- 1) MATERIAL: MAKE FROM D5569-3TRN
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
 - 7) WEIGHT: 0.98 lbs

APPROVED	DESIGN	AJS	DART AEROSPACE LTD	
	DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA	
	CHECKED	MW	DRAWING NO.	REV. C
	MFG. APPR.	RQ	D5569	SHEET 3 OF 4
	APPROVED	NO	TITLE	SCALE
	DE APPR.	CP	SKIDTUBE BLADE	NTS
	DATE	19.04.04	COPYRIGHT © 2017 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

D

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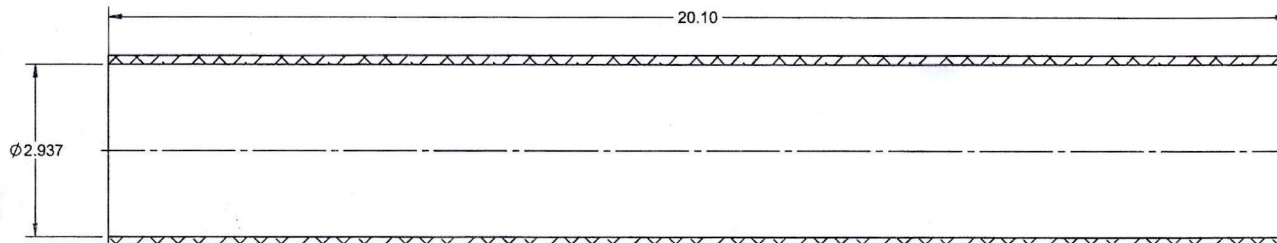
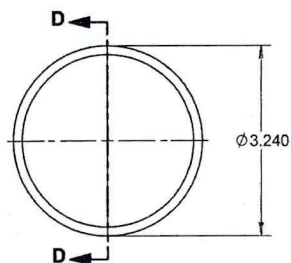
C

B

B

A

A



D5569-3TRN - TURNING DETAIL

SECTION D-D

NOTES:

- 1) MATERIAL: MAKE FROM D6008-132
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.98 lbs

RELEASED

2019 JUN 19 NO

APPROVED

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ZF		
CHECKED	MW	DRAWING NO.	REV. C
MFG. APPR.	RQ	D5569	SHEET 4 OF 4
APPROVED	NO	TITLE	SCALE
DE APPR.	CP	SKIDTUBE BLADE	NTS
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8 7 6 5 4 3 2 1

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			
Other/Details:					